

Work Order ID 69108

Monday, May 02, 2011 11:02:25 AM

Page 1

Item ID: D350-748-101

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 Start Qty: 1.00

Required Date: 5/16/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-748-141

F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-101

CHG002

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

5 u/04/79

DD 11-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Stress relief

Heat treat crosstube as per QSI010 4.3

Temp: 376

Start time: 5h41

Finish time: 9h41

SAD 11-06-28



127

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

84606129



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-141								
	4-Remove all marks from tube within limits of D350-748-141								
	5- Apply a light coat of LPS3 on the interior of tube Batch: <u>109156</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							
	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

ITW 11-06-28
SAD
11-06-28

Pro →

8 w/det/g

XC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D38-742-101 PAR #: _____ Fault Category: Landing Gear NCR: Yes No DQA: _____ Date: _____
 Resolution: As is Disposition: As is QA: N/C Closed: _____ Date: _____

NCR: <u>69108</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/6/73</u>	<u># 130</u>	<u>x-tube was drilled before they were stress rel'd. P.C. new process and wasn't recognized on w/o LQA</u>		<u>have stress relief performed after drilling</u> <u>Acceptable this time only</u>				<u>S</u> <u>11/6/73</u>

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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O:

14394

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

CL 11/06/30 (1)

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Prime Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS								

W/O:		WORK ORDER CHANGES					
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[illegible]

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Accept

Setup Start

Author's address: Department of Psychology, University of California, San Diego, La Jolla, CA 92037, USA.
E-mail: jkagan@ucsd.edu

Stop

Start Date: 5/2/2011 **Start Qty:** 1.00

1. [REDACTED]
 2. [REDACTED]
 3. [REDACTED]
 4. [REDACTED]
 5. [REDACTED]
 6. [REDACTED]
 7. [REDACTED]
 8. [REDACTED]
 9. [REDACTED]
 10. [REDACTED]
 11. [REDACTED]
 12. [REDACTED]
 13. [REDACTED]
 14. [REDACTED]
 15. [REDACTED]
 16. [REDACTED]
 17. [REDACTED]
 18. [REDACTED]
 19. [REDACTED]
 20. [REDACTED]
 21. [REDACTED]
 22. [REDACTED]
 23. [REDACTED]
 24. [REDACTED]
 25. [REDACTED]
 26. [REDACTED]
 27. [REDACTED]
 28. [REDACTED]
 29. [REDACTED]
 30. [REDACTED]
 31. [REDACTED]
 32. [REDACTED]
 33. [REDACTED]
 34. [REDACTED]
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 36. [REDACTED]
 37. [REDACTED]
 38. [REDACTED]
 39. [REDACTED]
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 41. [REDACTED]
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 44. [REDACTED]
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 80. [REDACTED]
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 92. [REDACTED]
 93. [REDACTED]
 94. [REDACTED]
 95. [REDACTED]
 96. [REDACTED]
 97. [REDACTED]
 98. [REDACTED]
 99. [REDACTED]
 100. [REDACTED]

Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00

[illegible]

Customer:

Reference:

Run Start

[illegible]




Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
220 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							
230 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 5/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPP D350-748-101								
	Location: _____								
	PPP Rev: _____								
250	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, May 02, 2011 11:02:32 AM

Page 1

Work Order ID: 69108

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011

Required Date: 5/16/2011




Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 06-07-05 JLM
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev:C Rev B 07-11-15 DD
 IPP Rev D Combined manufacturing 08.04.02 EC verified
 IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC
 10.08.04 added QSI010 4.3 DD verf:EC

W/O found in shed

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	La Loc	Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN		Manufactured	No			110	Each	1.0000	1			
 Crosstube Turning Detail												
<div> <div><i>B68817</i></div> <div> <u>Location</u> LG046 64475 </div> </div>												
<div> <div><u>Loc Qty</u></div> <div>1</div> </div>												
ALS4-1032-225		Purchased	No			200	Each	1.069.000	1			
 Insert												
<div> <div><u>Location</u></div> <div> FP-B 110768 ST282 110768 </div> </div>												
<div> <div><u>Loc Qty</u></div> <div> 28 28 1041 1041 </div> </div>												
AN960JD10	NAS1149D0363J	Purchased	No			200	Each	0.0000				
 Washer												

11-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, May 02, 2011 11:02:32 AM

Page 2

Work Order ID: 69108

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

200 f

215.2696

1.181

1.243158



Abraison Strip

Location

Loc Qty

Loc Code

ST403

214.6

68076

214.6

ST409

0.6696

63735

0.6696

D3502-1

Manufactured No

200 Each

31.0000

2

2



Support

Location

Loc Qty

Loc Code

ST063

31

61206

12

61843

9

64004

10

MS21920-20

Purchased No

200 Each

72.0000

2

2



Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

72

116799

22

117279

50

MS27039-1-10

Purchased No

200 Each

217.0000

1

1



Screw

Location

Loc Qty

Loc Code

ST290

150

117441

150

ST291

67

115935

67

Monday, May 02, 2011 11:02:32 AM

Shop Packet Print

Page 2

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Start Date: 5/2/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-41A Purchased No

220

Each

198.0000

8

8



Bolt

Location

Loc Qty

Loc Code

ST360

198

115108

98

115705

50

116191

50

AN4-6A Purchased No

220

Each

1,162.000

16

16



Bolt

Location

Loc Qty

Loc Code

ST356

962

115936

159

116191

3

116400

400

116924

400

ST358

200

117514

200

AN5-32A Purchased No

220

Each

159.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

159

115589

59

117161

50

117514

50

AN960JD416 NAS1149D0463J Purchased No

220

Each

0.0000

32

32



Washer

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Shop Packet Print

Page 3

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Start Date: 5/2/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No

220

Each

0.0000

8

8



Washer

D3500-1 Manufactured No

220

Each

44.0000

4

4



Saddle

Location

Loc Qty

Loc Code

ST424

9

66127

9

ST424/25

20

62207

20

ST425

15

61838

15

D3501-1 Manufactured No

220

Each

67.0000

16

16



Bushing

Location

Loc Qty

Loc Code

ST063

67

61984

67

MS21042L4 Purchased No

220

Each

4,748.000

24

24



Nut

Location

Loc Qty

Loc Code

ST300

4748

116823

1748

117441

3000

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Shop Packet Print

Page 4

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Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011

Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

220

Each

1,171.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

1171

116105

411

116548

260

117441

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

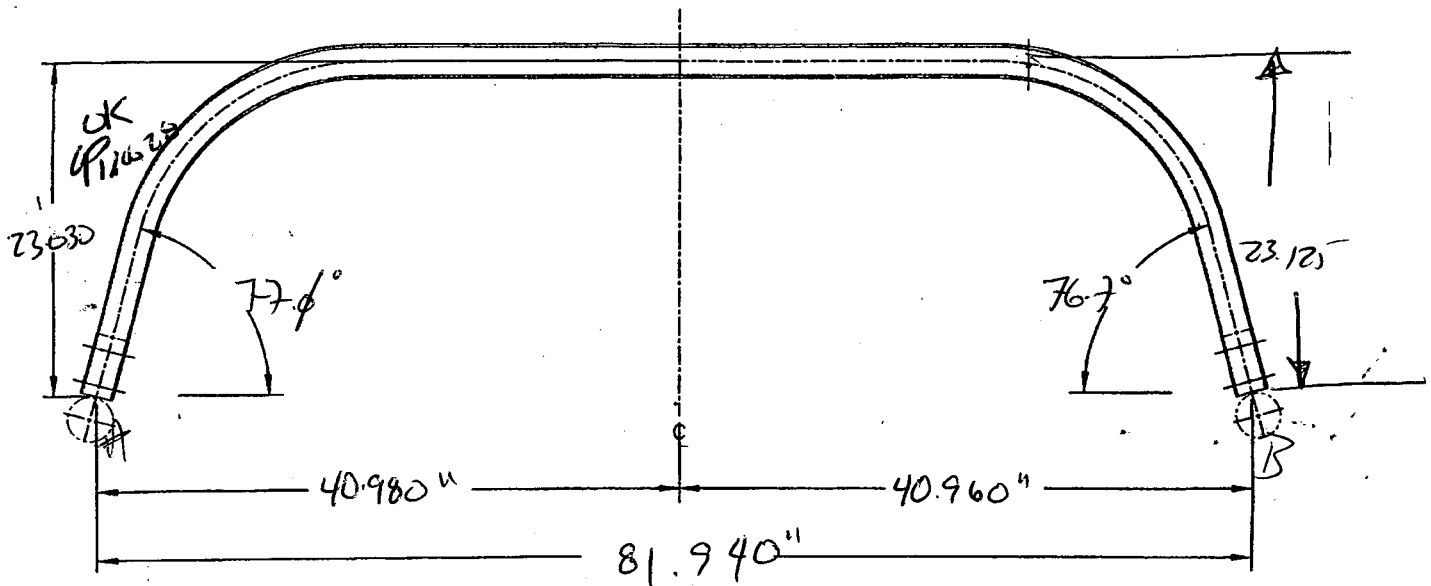
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DART AEROSPACE LTD		Work Order:	09188
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
twist = 0.142"
Send low. Acceptable 11.06.23

QC15 Inspection	8/16/23
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty	Part Number	Description
	-141		
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOMSIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

RELEASED
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-141	REV. F SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
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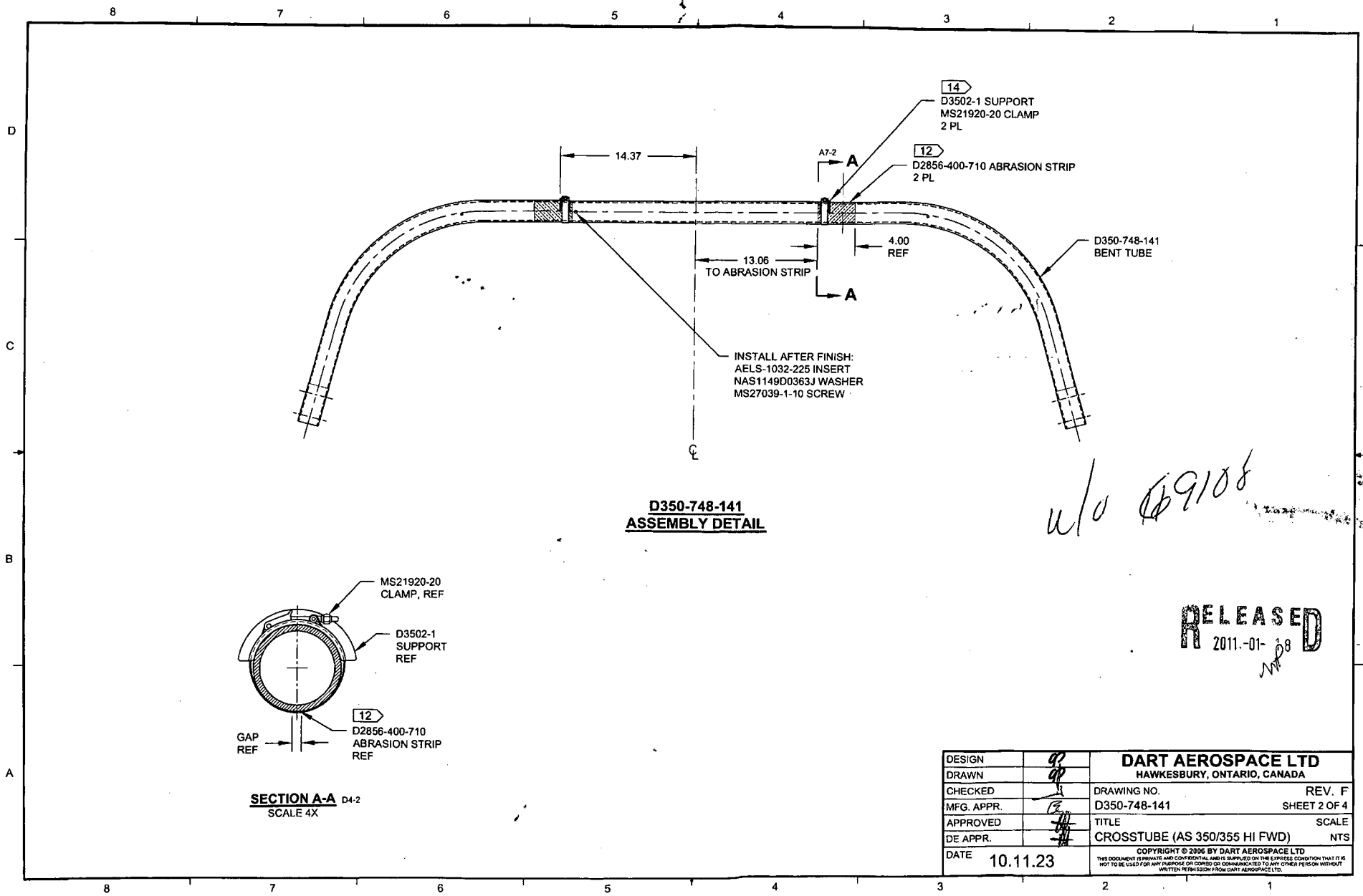
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D350-748-141
ASSEMBLY DETAIL**

RELEASED
 2011-01-08

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D350-748-141	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

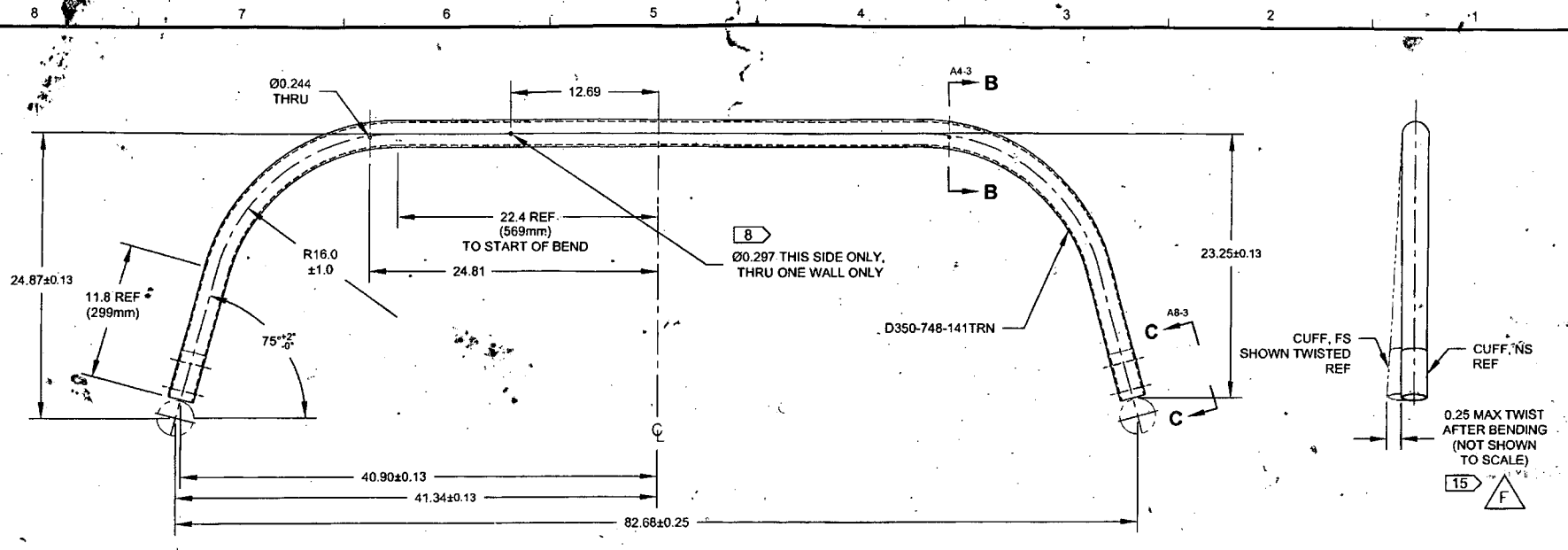
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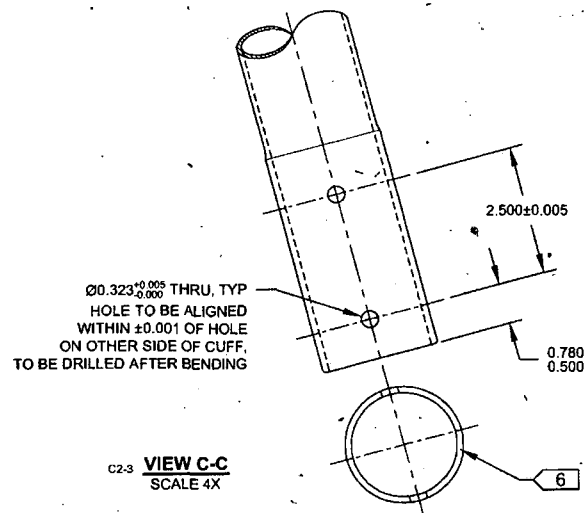
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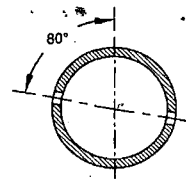
NOTE: Date & initial all entries



D350-748-141
BENDING AND DRILLING DETAIL 10



VIEW C-C
SCALE 4X



SECTION B-B D3-3
SCALE 4X

u/v 49108

RELEASED
2011-01-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D350-748-141	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

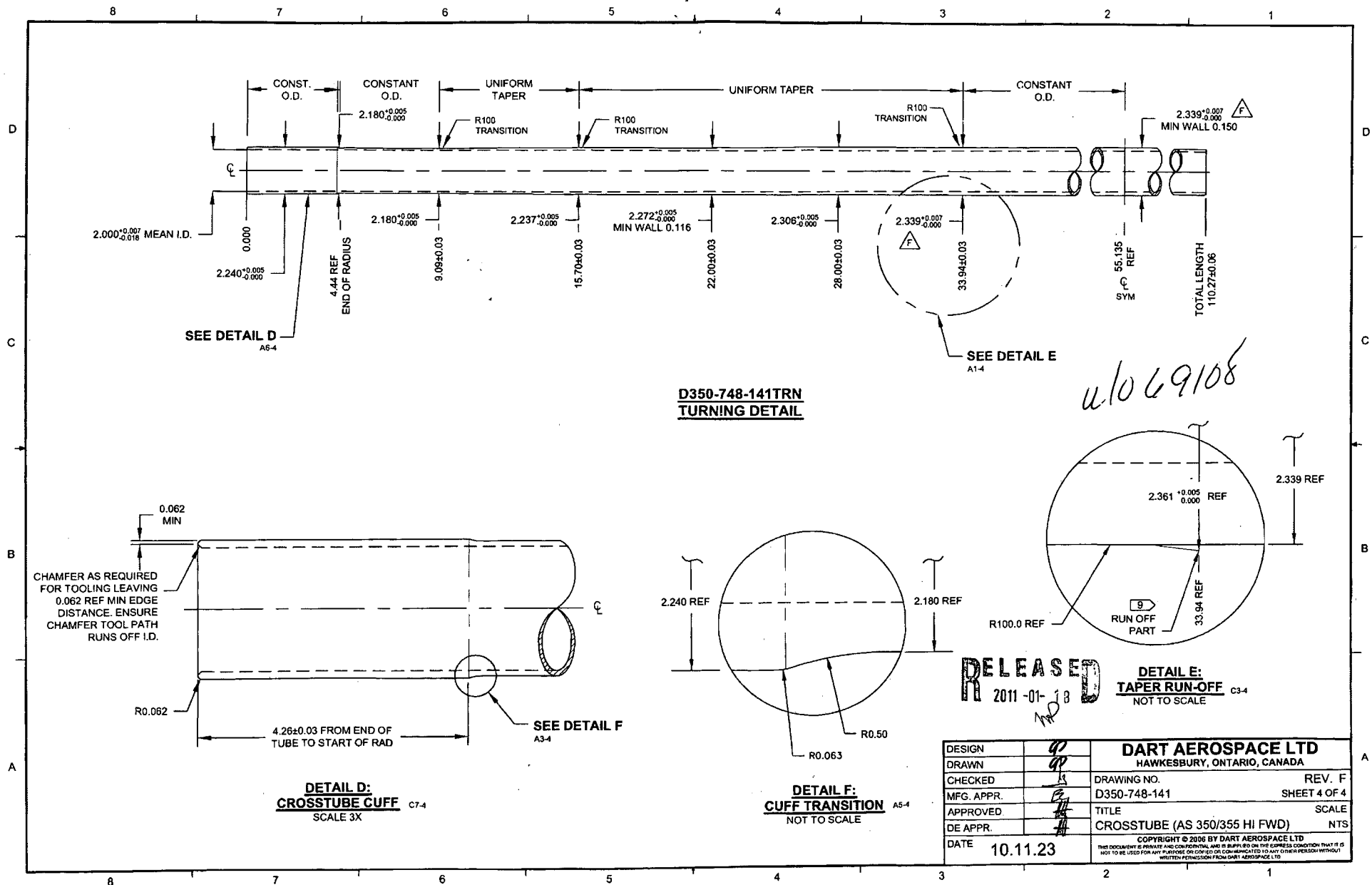
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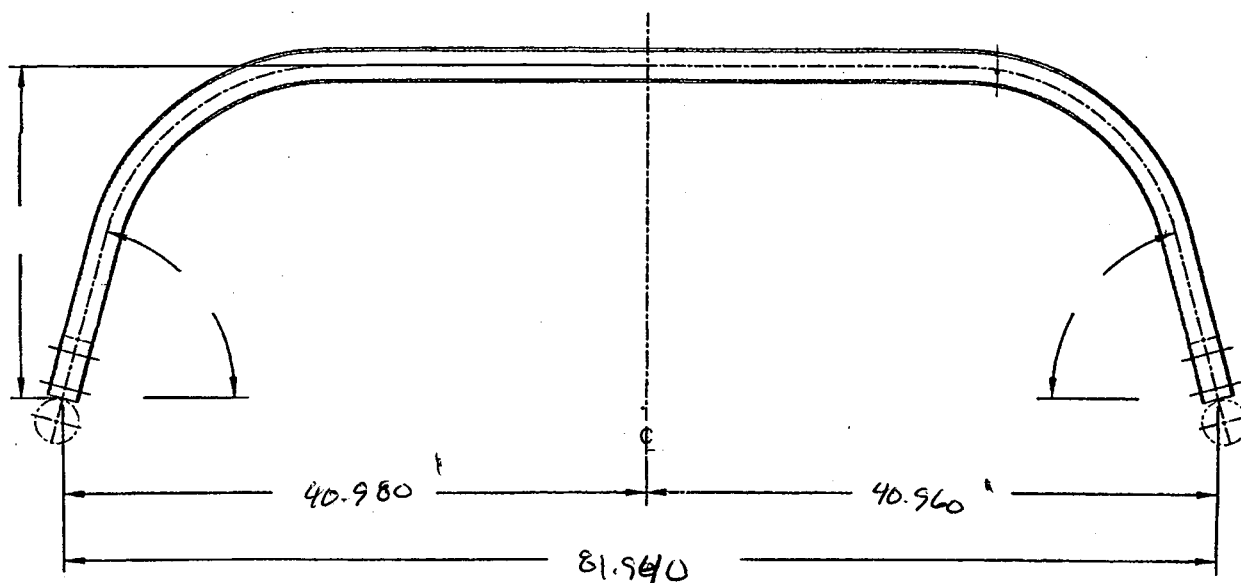
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36908
Description: Crosstube High Fwd (AS350/355)	Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: E		Page 1 of 1

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
AFTER Stress Relief.
twist = 0.136"

QC15 Inspection	<i>[Signature]</i>
Date	11/06/29

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

[Signature] 11/06/23

18 2014

CADORATH GROUP
NON CONFORMANCE REPORT

CADORATH AEROSPACE ☐

CADORATH DISTRIBUTION ☐

CADORATH COATING ☒

UNIFLYTE ☐

NOTE: THIS FORM MUST BE COMPLETED BY: CUSTOMER ☒ VENDOR ☐ BEFORE PROCESSING OF PART(S)

NCR#: **0185**

CUSTOMER: ☒ **Dart Aerospace Ltd.**

DATE: **07/07/11**

VENDOR: ☐ **N/A**

CADORATH/UNIFLYTE P/O #:

N/A

PART DESCRIPTION: **Skid (Crosstube)**

CADORATH/UNIFLYTE W/O #:

105861

CUSTOMER P/O #: **PO 14394**

PART #: **d350-748-101**

SERIAL #: **N/A** QUANTITY: **One (1)**

PURCHASE ORDER INSTRUCTIONS: **Cadmium Plate**

DISCREPANCY: **As per Don's email to you this morning, this one passed MPI and was plated and baked yesterday as per your po instructions. When they were dichromating it this morning an identical crack appeared. Please advise on how to proceed.**

Nick Wasylik (QA Manager)
CADORATH/UNIFLYTE INSPECTION DEPARTMENT



CUSTOMER: ☒

PLEASE COMPLETE THIS PORTION, SIGN AND RETURN TOP COPY OF THIS FORM TO CADORATH/UNIFLYTE

VENDOR: ☐

DATE: _____ P/O: **PO 14394**

CUSTOMER INSTRUCTIONS: ☒

ATTENTION: Chantal Lavoie

VENDOR CORRECTIVE ACTION: ☐

AUTHORIZED SIGNATURE

NAME AND TITLE

DATE: 10/13/10

FORM: OPS 097
REVISION: 3

10
57